

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017753**Date Inspected:** 29-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Jesse Cayabyab and John Pagliero			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006			Component:	Orthotropic Box Girder	

Summary of Items Observed:

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

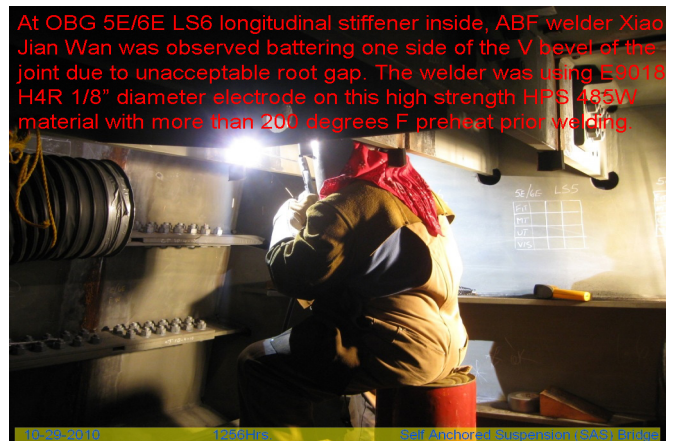
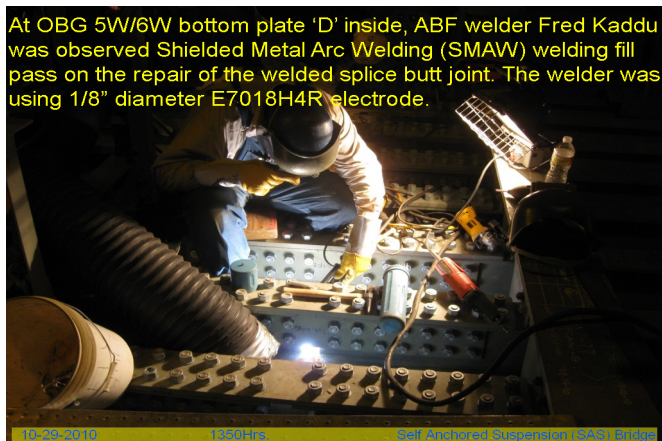
At OBG 5W/6W bottom plate 'D' inside, QA randomly observed ABF/JV qualified welder Fred Kaddu ID # 2188 perform CJP groove welding first time repair. The welder was observed welding in the 1G (flat) position utilizing Shielded metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode implementing welding procedure ABF-WPS-D15-1001-Repairs. The boat shape repair excavation having Y-dimensions of 3060mm to Y-3140mm was having 80mm long x 30mm wide x 13mm deep excavation. The repair excavation was preheated to more than 140 degree Fahrenheit using propane gas torch prior welding. During the shift, ABF QC Jesse Cayabyab was noted monitoring the welder. Prior welding, ABF QC Jesse Cayabyab was also observed performing Magnetic Particle Testing (MT) using Parker Contour Probe with red magnetic powder as detecting media on the repair excavation. There were no significant defects noted during the test.

At OBG 7E/8E side plate 'E' inside, ABF welder Songtao, Huang was observed 3G SMAW welding fill to cover pass on 0mm to 1000mm location of the splice butt joint. This location was welded manually using the SMAW due to limited access when using the automatic FCAW-G track mounted Bug-o nozzle holder. The welder was using 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1040A. During welding, ABF QC William Sherwood was noted monitoring the welder's welding parameters. At the end of the shift, welding on the location mentioned above was completed and the welder was noted preparing to move to the new location 8255mm to 10555mm of the same OBG plate.

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At OBG 6E/7E side plates 'C' and 'E' inside and outside, ABF QC Jesse Cayabyab informed QA that the two plates were ready for QA visual test (VT). This QA performed the 100% VT upon knowing that the plates were ready. During the VT of plate 'C' from the inside, there were six locations wherein undercut were noted and one location of undercut was noted from the outside. As for side plate 'E' inside, there were two locations wherein undercut were also noted and nothing from the outside. The outside plates were properly flush ground and the inside plates were having acceptable profiles except the undercut that were noted. ABF QC Jesse Cayabyab was notified by QA about the weld undercut that were noted.



Summary of Conversations:

No significant conversation occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Mohammad Fatemi (916) 813-3677, who represents the Office of Structural Materials for your project.

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

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Reviewed By: Levell,Bill

QA Reviewer